Work Order		253		*852	253*						Page 1	-
Item ID: I Revision ID:	D412-758-0	15	<u> </u>	Accept	*N900	0040	100)* s	etup Sta	rt *N	S1*	
Item Name:	GPSMAP Top	Mounted GPS Receiv	er Gimbal Mount						Sto	op *N	S2*	
Start Date: 0 Required Date: 1 Reference:	05/06/2012 19/06/2012	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item Customer:						. 1/	
		in: MLJ	_Date: 12/06/(ON Tooling: SPC (Y/N):		ate:	· ·	R	tun Sta Sto	1/1	R1* R2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	· ·
Draw Nbr	Rev	ision Nbr				• • • • • •						-
IIN-D412-758	C			•					·	•		
*100		DOCUMENT CONTRO	DL	0.00								
DC Document Control		Memo Phótocopy l	pluefile & type labels per P	0.00 PP412-758-015 CHG00	on 13 Eve	73	_					
110 .		Pick Kit		0.00								
110 Packaging		Memo	·	0.00				7			12/06/	26 fB
Packaging												
115 * 447		QC4- 100% Inspect kits	for completeness	0.00								
115 QC		Memo		0.00	C 17/00/13			(+2)		<u> </u>		

Page 2 June-05-12 9:11:59 AM Item ID: D412-758-015 Accept Setup Start *N900040100* Revision ID: Item Name: GPSMAP Top Mounted GPS Receiver Gimbal Mount **Start Date:** 05/06/2012 Start Otv: 2.00 **Cust Item ID: Required Date:** 19/06/2012 Rea'd Oty: 2.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: ___ Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description Run Hours Qty Code Qty Number Stamp 120 0.00 Packaging *120* Packaging Memo Packaging Identify and pack for shipping as per PPP D412-758-015 Location: PPP Rev: 130 QC21- Final Inspection - Work Order Release 0.00 *120* MF 12-09/3 OC 0.00 Memo Quality Control

Picklist Print

June-05-12 9:12:03 AM

Work Order ID: 85253

85253

D412-758-015

Parent Item: D412-758-015 *D412-758-015*

Parent Item Name: GPSMAP Top Mounted GPS Receiver Gimbal Mount

Start Date: 05/06/2012

Required Date: 19/06/2012

Page 1

Start Qty: 2.00

Required Qty: 2.00

Cor	mments: IP	P rev:A 10.06.21	new issue DI) veri	fied by:EC					tart Qty. 2.00		Require	a Qty: 2.00	,
Cor	mponent Item ID/ m Name	Replacement Item ID		Bin Item		Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
[Brace	731-041 73531-04 cket Assembly	.1	Manufactured	No			.110	Each	0.0000	**	2	342	12/13	
X BD24	72464*		Manufactured	No			110	f	583.6406	1.05	2.210520	5 B S	34637	
- -~	qiy of 2 at 6.6" as per dwg	517/154/76 517/154/76 D2464-0066 ***pe	er			61878 83543			Loc Code		7354	-3		•
D35	25-1 33525-1 *	a r	Manufactured	No			110	Each	8.0000	**	2 /	JB		
					Location ST053	81318	<u>Loc (</u>	<u>2tv</u> 8 8	Loc Code		113N	•		
	15-1/ 13645-1*		Manufactured	No			110	Each	32.0000	**	8 2	JB	127	106/25
						35024 35025	<u>Loc (</u>	20 20 20 20	Loc Code	-4 2 43	5024	,		·

NCR: Yes	/ No				WORK ORDER NON-	\mathbf{c}	NEOD	MANICE / LID	D 4 T-	DQA	\: Da	te:
					The state of the s		INFOR	INIANCE / UP	DAIE	QA Closed	l: Da ^r	te·
Work Order:					DISPOSITION				AGAINST	DEPARTMEN		
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Sto	od. Eng. Coor. Ore/Packaging Supplier Other	Engineering Quality
Root Cause Doc/Data	Date	Step	Qty		ption of work order update or Non-conformance	1	nitial ief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Operator Waterial Offset/Setup Other Process upplier raining nauthorized												
landin 6				·	F/	AULT	CATE	GORY				
Landing G					Hardware			General				
C C C C C C C C C C	Cracks Crushed/Crushed/Crusher Positioned Ripples on Forque War	rimp at B Strip in T Wrong Inner Ber ves in Ext quence	tric to O/S sending Tube and trusion		Breaking Missing Size/Length Spinning Threading Wrong Drill Holes Misaligned Over/Undersized	C C F Ir Ir	inish Ispectio Ispectio Istructio	Short Intation/Data Incomplete In Unqualified Ins Incomplete/Un	oclear	Maintenand Mislabeled Off-Set Orientation N Out of Calibra Out of Seque Outside Dime Over/Under t Part Lost Part Moved	Misread ation ce	Set-up Supplier Temperature/Cure Weld Wrong Stock Pulled Other
/FORMS/Quality As	Vave/Twist			<u> T</u>	oo Many	Kit Missing				Raw Material		

June-05-12 9:12:03 AM

Work Order ID: 85253

85253

Parent Item:

Parent Item: D412-758-015 *D412-758-015*

Parent Item Name: GPSMAP Top Mounted GPS Receiver Gimbal Mount

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 2.00

Required Qty: 2.00

AN525-10R7

Purchased

No

No

No

110 Each

Location	Loc Qty						
ST345	242						
115371	7						
118686	100						
120833	2						
121390	133						
	110 Each						

200.0000

Loc Code

242.0000

Location Loc Qty Loc Code ST298 200 118428 200 110 Each 0.0000

110

Purchased

NAS1149D0363J Purchased

Purchased

No

232.0000

Location Loc Qty Loc_Code ST300 232 118354 119109 119758 121444 128 121556 100

Each

NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORI	MANCE / UPI	DATE					•
												QA Closed:	Dat	e:	
Work Ord	or:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part				,		Rework Scrap			Skid-tube Machining	Crosstube Small Fab		4	d. Eng. Coor. re/Packaging		Engineering Quality
NCR						Use-as-is Work Order Update			noforming Large Fab	Finishing Composite			Supplier Other		
Root					Descri	ption of work order update	Τ	Initial	Act	ion		Sign &			
Cause		Date	Step	Qty	-	or Non-conformance	Cł	nief Eng	Descr	iption		Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Offset/Setup Other Process Supplier Training Unauthorized															
					<u>-</u>		AU	LT CATE							
Land	ing (7			_	Hardware	_	7_	General			7	Г	_	_
		Bending Centre N			_	Breaking Missing		-	Burrs Contamination			Maintenan Mislabeled	ce	-	Set-up Supplier
-		Cracks				Size/Length		Cut Too	Short			Off-Set		\neg	Temperature/Cure
		Crushed/	Crimp at	Bendin	g 🗀	Spinning		Docume	entation/Data			Orientation	Misread	٦	Weld
	Inspection Strip in Tube			Threading		Finish				Out of Calib	ration		Wrong Stock Pulled		
	Other			Wrong		Inspecti	on Incomplete			Out of Sequ	ence				
		Positione	ed Wrong			Drill Holes		Inspection Unqualified				Outside Dim	ensions		Other
		Ripples o	n Inner B	end		Misaligned		Instruct	ions Incomplete/l		Over/Under tolerance				
		Torque V	Vaves in I	Extrusio	n [Ovalized		Jigs/Fixt	ures/Tooling			Part Lost	_		
	Turning Sequence			!		Over/Undersized		Kit Incorrect				Part Moved	_		

Kit Missing

DQA:

Raw Material

Date:

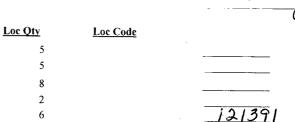
Wave/Twist in Tube

Too Many

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F



110 Each 13.0000



**

Location

120639

121307

121391

ST382

ST396

• June-05-12 9:12:03 AM

Work Order ID: 85253

85253

No

MS21042L3

Parent Item: D412-758-015 *D412-758-015*

Parent Item Name: GPSMAP Top Mounted GPS Receiver Gimbal Mount

Purchased

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 2.00

Required Qty: 2.00

2,157.000

**

JB 12/06/26

Loc Qty	Loc Code	
2157		
32		
952		
138		
215		
820		121444
	2157 32 952 138 215	2157 32 952 138 215

Each

110

DART AEROSPACE LTD.



5.0 PARTS_LIST

		51		
QTY	QTY	ZOTY.	Part Number	Description
-011	-013	-015	Prairivumber	-
Х			D412-758-011	Bottom Mounted GPS Receiver Gimbal Mount
	Х		D412-758-013	Top Mounted GPS Receiver Gimbal Mount
		X	D412-758-015	GPSMAP Top Mounted GPS Receiver Gimbal Mount
1			D3514-041	Bottom Mounted Gimbal Assembly
	1		D3514-043	Top Mounted Gimbal Assembly
	4	1	D3531-041	Bracket Assy.
		Lar Cambridge		
	2 /	2	D2464-0066	Neoprene Seal
1	17	1	D3525-1	Placard
1	1		D3527-1	Support Arm
1			D3530-1	Base Plate
1			D3530-3	Mounting Plate
1	1		D3534-1	Doubler
	4 /	4	D3645-1	Washer ·
	4 /	7	AN525-10R7	Screw
3			AN526-632R7	Screw (or MS35206-229)
3	_	- 4	AN960JD6	Washer
2	4	7	AN960JD10 /	Washer
3	1	, 4	MS21042L06	Nut
1		[*] 3	MS21042L3 /	Nut
4	4		MS24693-S27	Screw
1			MS27039-1-09	Screw
		4	MS24693-S29/	Screw
		E Proposition Control	350 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3	
		1 2	RAM-B-201U-A /	Socket Arm, 1.75"
		2	_RAM-B-202U	Round Plate Mount, Single 1" Ball
		1 1	RAM-B-217U	Round Plate Mount, Dual 1" Ball

